| NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date: | | | | | | | | | | | | DQA | .: Date | e: | |
|---|------------|----------|----------|------------|-----------|------------------|--------------------|----------|------------|---------------------|---------------------------------------|-------------|---------------------------------|------------|--------------------|
| Work Order: Part No. | NCR: | Yes | / No | | | | WORK ORDER NON-O | COI | NFORN | MANCE / UPD | ATE | | | | • |
| Work Order: Part No. Scrap Use-as-is NCR No. Description of work order update Date Step Qty Or Non-conformance Composite Description Doc/Data Equip/Tooling Operator Operator Training Unapproved Landing Gear Bending Centre Not Concentric to O/S BOM/Route Rework Skid-tube Crosstube Nachining Small Fab Prod. Eng. Coor. Thermoforming Finishing Nachining Skid-tube Crosstube Nachining Skid-tube Nachining Skid-tube Crosstube Nachining Skid-tube Nachining Skid Nachining Nachining Skid Nachining | | | : | | | | | | | | | QA Closed | : Date | e: | |
| Rework Scrap Use-as-is Work Order Update Verification Of Non-conformance Chief Eng Description Date Verification Of Non-conformance Chief Eng Description Date Verification Of Non-conformance Chief Eng Description Of Non-conformance Chief Eng Description Date Verification Of Non-conformance Chief Eng Description Of Non-conformance Chief Eng Description Date Verification Of Non-conformance Chief Eng Date Verification Of Non-conformance Chief | Work Orde | or. | | | | | DISPOSITION | | | | AGAINST DE | PARTMEN | T/PROCESS | | ù |
| Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Operator | Part f | No. | | | | | Scrap Use-as-is | | N Therm | Machining loforming | Small Fab Finishing | 4 | od. Eng. Coor. ore/Packaging | | Quality |
| Cause Date Step Qty or Non-conformance Chief Eng Description Date Verification QC Inspector Doc/Data Equip/Tooling Operator | | | | r | | | | | | A - 4 * | | Ciar 0 | | | |
| Doc/Data | | | Doto | Chan | Otre | | , | 1 | 1 | | | 1 | Varification | | OC Inspector |
| Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved Handing Gear General Sending Centre Not Concentric to O/S BOM/Route Grain Hardware Over/Under tolerance Temperature/Cure | — | I . | Date | Step | Qty | | or Non-comormance | | ner Eng | Descri | ption | Date | Vermeation | + | QC IIIspector |
| Operator Material Setup Other Other Process Supplier Training Unapproved Landing Gear Bending Centre Not Concentric to O/S BOM/Route FAULT CATEGORY Grain Hardware Ovalized Over/Under tolerance Temperature/Cure | | \vdash | | | | | | 1 | , | | | | | | |
| Material Setup Other Process Supplier Training Unapproved FAULT CATEGORY Landing Gear General Bending General General General General General Ovalized Over/Under tolerance Temperature/Cure | | - | | | | | | | | | | | | | |
| Setup Other Process Supplier Training Unapproved Landing Gear Bending Centre Not Concentric to O/S BOM/Route FAULT CATEGORY Grain Hardware Ovalized Over/Under tolerance Temperature/Cure | l i | \vdash | | | | | | | | | | | | | |
| Other Process Supplier Training Unapproved FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure | | \vdash | | | | | | | | | | | İ | | |
| Process Supplier Training Unapproved FAULT CATEGORY Landing Gear General Bending Centre Not Concentric to O/S BOM/Route Grain Hardware Ovalized Over/Under tolerance Temperature/Cure | 1 | Н | | | | | | | | | | | 1 | | |
| Supplier Training Unapproved FAULT CATEGORY Landing Gear General Bending Centre Not Concentric to O/S BOM/Route Grain Hardware Ovalized Over/Under tolerance Temperature/Cure | | \vdash | | | | | | | _ | | | | | | |
| Training Unapproved FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure | | \vdash | | | | | | | | | | | | | |
| FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure | 1 | H | | | | | | | | | | 1 | | | |
| FAULT CATEGORY Landing Gear General Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure | i - | \vdash | | | | | • | | | | | ļ | | | |
| Landing Gear Bending Bend Bend Centre Not Concentric to O/S BOM/Route General Grain Hardware Ovalized Over/Under tolerance Temperature/Cure | Unapproved | 1 | | <u> </u> | <u> </u> | | | <u> </u> | T CATE | COPY | | <u> </u> | | | · |
| Bending Bend Grain Ovalized Pressure/Forced Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure | Landi | na (| Gear | · | | | | 701 | CATE | JOK1 | · · · · · · · · · · · · · · · · · · · | | | | |
| Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Temperature/Cure | Land | , E | 3 | | | | - | Г | Grain | | | Ovalized | Γ | | Pressure/Forced |
| | | \vdash | 1 | nt Concer | atric to | | 4 | - | 4 | rο | <u> </u> | ⊣ i | er tolerance | | • |
| | | <u> </u> | ł | or contect | iti ic to | 5/3 | - | \vdash | 1 | | <u> </u> | | F | | • |
| Crushed/Crimped. Burrs Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled | | \vdash | ł | Crimned | | | | - | 4 ` | · · | nclear | - | | _ | |
| Cuffs Contamination Maintenance Part Moved | | _ | 1 | cimpeu. | | - | 4 | \vdash | ┥ | • | - Icicai | ⊣ | | ' ^ | TIONS STOCK I UNEU |
| Heat Treat Countersink Mislabeled Positioned Wrong | | _ | (| ıt | | | 4 | \vdash | 4 | | <u> </u> | -{ | | | |
| Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Other | | - | | | Tuha | - | 4 | \vdash | -1 | | | -1 | | \neg | Othor |
| Ripples in Bend Drill Holes Offset | | | | • | TUDE | | 4 | \vdash | 4 | ı | <u> </u> | Ti owei ros | o) anige [| | ZHEI |

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

| Work Ord | | | | *934 | .91* | | | | | | Page 2 | 2 |
|-------------------------------|------------------------|--------------------------------------|--------------------------|----------------------|--------------------------|------------|----------------------|-------|---------------|------------------|----------------|------|
| Item ID: Revision ID: | D206-781-0 | 23 | | Accept | *N900 | 040 | 100* | Setup | Start | | S1* | |
| Item Name: | Floor Protect | or (Passenger Cabin) | | | | | | | Stop | *N3 | S2* | |
| Start Date: Required Date: | 11/15/12 : 11/16/12 | Start Qty: 2.00 Req'd Qty: 2.00 | *2* *2* | | Cust Item I Customer: | D: | | | | | | |
| Reference: | | | - | • | | | | - | C44 | | | |
| Approvals: | | an: | Date: | | | ate: | - · · | Run | Start Stop | *N! | R1* | |
| | QC: | | Date: | SPC (Y/N): | Da | ate: | | | | ^ N I | R2* | |
| Sequence ID/ Work Center I | D | Operation Description | | Set Up/ Run Hours | Tool ID | | Plan Acc Code Qty | | • | Reject Number | Insp. Stamp | 20 |
| *130* Packaging | | Memo | | 0.00 | | | 27/ | | Jul 1 | 99 S | ۲. | · £5 |
| Packaging | | Identify and Location PPP rev: | pack for shipping as per | PPP D206-781-023 | | | | | | | | |
| 140 | | QC21- Final Inspection | Work Order Release | 0.00 | | | | ı | _ 1 | 1 | 2 d | 7 |
| *140* | | Memo | | 0.00 | | | *** | | 0/1 | 1/8 | J4 | / |
| Quality Control | | | | | | | | | | √n | NF -11- | 22 |

| NCR: | Yes | / No | | | | WORK ORDER NON-C | | NFORM | MANCE / UPI | DATE | | | |
|----------------|----------|------------|-----------|------------|-------------|------------------------------|----------|----------|-------------------------------|-------------------------------------|--------------|--------------------------------------|---------------------------|
| | | | | | | | | | | | QA Closed: | Date: | \ |
| Work Ord | er: | | | | | DISPOSITION | | | | AGAINST DE | PARTMENT | /PROCESS | † |
| Part | • | | | | | Rework Scrap Use-as-is | | 1 | Skid-tube Machining noforming | Crosstube Small Fab Finishing | ł | Water Jet d. Eng. Coor. re/Packaging | Engineering Quality Other |
| NCR | No. | <u> </u> | | <u> </u> | | Work Order Update |] | | Large Fab | Composite | | Supplier | |
| Root | | | | | Descri | ption of work order update | | nitial | Act | tion | Sign & | | |
| Cause | | Date | Step | Qty | • | or Non-conformance | Ch | ief Eng | Desci | ription | Date | Verification | QC Inspector |
| Doc/Data | | | | | | | | | | | | | |
| Equip/Tooling | | | | | | | ļ | | | | | | |
| Operator | | | | | | | 1 | | | | | | |
| Material | <u> </u> | | 1 | | | | | | | | | | |
| Setup Other | Ш | | | | | | | | | | | | |
| 1 | Щ | | | | | | | | | | | | |
| Process | | | | | | | | | | • | | | |
| Supplier | | | | | | | | | | | | | |
| Training | \vdash | | | | | | | | | | | | |
| Unapproved | <u>i</u> | <u> </u> | <u> </u> | <u> </u> | | | <u> </u> | T CATE | CORV | | L | 1 | 1 |
| Landi | na (| | | | | General | HUL | .I CATE | GORT | | 1.8 | | |
| Land | lig (| Bending | | | | Bend | | Grain | | | Ovalized | | Pressure/Forced |
| li l | \vdash | Centre No | nt Concer | ntric to I | | BOM/Route | - | Hardwa | ire | <u> </u> | Over/Under | tolerance | Temperature/Cure |
| | | Cracks | or conce. | ittie to |), <u> </u> | Broken/Damaged | \vdash | ł | ion Incomplete | | Part Incorre | <u> </u> | Weld |
| | _ | Crushed/ | Crimped | | | Burrs | | 1 | tions Incomplete/ | Unclear | Part Lost/M | <u> </u> | Wrong Stock Pulled |
| | - | Cuffs | | | | Contamination | | Mainte | • | | Part Moved | | |
| | - | Heat Trea | ıt | | | Countersink | | Mislabe | | | Positioned V | | |
| | - | Inspection | | Tube | | Cut Too Short | | Misread | | | Power Loss/ | | Other |
| | - | Ripples in | - | | | Drill Holes | | Offset | | L | <u>.</u> | <u> </u> | |
| | Г | Torque W | aves in E | xtrusio | n | Drawing | | Out of (| Calibration | | | | |
| | | Turning S | equence | | | Finish | | Out of S | Sequence | | | | |

Outside Dimensions

DQA:____

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

Ngvember-15-12 1:03:07 PM

Work Order ID:

93491

Parent Item:

D206-781-023

Parent Item Name:

Floor Protector (Passenger Cabin)

Start Date: 11/15/12

Required Date: 11/16/12

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD verified by:EC

| | verified by:EC | | | | | | | | ···· | | | | |
|---|------------------------|---------------|-------------|------------------------------------|------------------|---|--------------------|----------------|----------------|--------------|---------------|----------------|--------|
| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
| D3898-0 Floor Protector (206L) | 5ms dp | Manufactured | No | | | 110 | Each | 0.0000 | | 2 | 926 | 57 | /// |
| D3934-041 Clip Assembly | | Manufactured | No | | | 110 | Each | 16.0000 | 23 | 4 | ~ (- | | - |
| | X6 Cmi | | | Location | | Loc Oty | Lo | c Code | • | | _ | | |
| | | | | ST074 8995 | 59 | 16 16 | | | 89 | 959 | | | // - |
| D3800-0-100 Hook and Loop Strip (1" S | Soft) | Manufactured | No | | | 110 | f | 124.2224 | (8333) | 16.66 | 6 ` | | |
| (D3800-1-100-500) cut (2 kit** |) at 50.00" as per dwg | **per | | Location | | Loc Qty | Lo | oc Code | | | | | |
| 47 50, | Sm) | X | | ST065 689 7222 800' 8533 ST088 | 33 73 54 | 74.2204 9.801 9.841 1.1734 53.405 50.002 50.002 | | | 83 | 364 | | | |
| 03800-3-100 Hook and Loop Strip (1" I | Hard) | Manufactured | No | 0.101 | | 110 | f | 114.0210 | E 62333 | 16.66 | 6 | | |
| (D3800-3-100-500) cut (2 | | **per | | Location | | Loc Qty | <u>La</u> | oc Code | | | | | |
| cit** | 610 | 7 | | ST065 | | 114.021 | | | | | | | |
| U+ 50" | SWS | | | 689 | | 18.301 | | | | <u> </u> | | | |
| | | | | 727 | | 2.341 | | | | | | | |
| | | | | 730 | | 5.001 | | | | | | | |
| | | | | 751 | 05 | 13.67 | | | | - | | | |

80077 84061

85355

15.536

9.967

49.205

. IPP Rev:B add comment for d3800 DD 10.03.08

| NCR: | Yes | / | No |
|------|-----|---|----|

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: ____ Date: ____

| NCR: | res | / No | | | | WORK ORDER NON- | COI | NFORN | MANCE / UPL | DATE | QA Closed: | Date: | * |
|---|------|---|---------------|-----------|----------|---|-----|---------|--|---------------------|--|-------------------------|--|
| Work Orde | or. | | | | | DISPOSITION | | | | AGAINST DI | PARTMENT | PROCESS | à |
| Part I | • | | | | | Rework Scrap | | ı | Skid-tube Machining | Crosstube Small Fab | ⊣ | Water Jet d. Eng. Coor. | Engineering Quality |
| NCR f | No. | | | | | Use-as-is Work Order Update |] | • | noforming Large Fab | Finishing Composite | Rec/Stor | e/Packaging Supplier | Other |
| Root | | | | | Descr | iption of work order update |] | nitial | Acti | ion | Sign & | | |
| Cause | | Date | Step | Qty | - | or Non-conformance | Ch | ief Eng | Descr | iption | Date | Verification | QC Inspector |
| oc/Data quip/Tooling perator faterial etup other rocess upplier raining napproved | | | | | | | | | | | | | |
| | | | · | | | F | AUL | T CATE | GORY | | • | | |
| Landi | ng (| Gear | | · | | General | | | | | | | |
| | | Bending Centre No Cracks Crushed/C Cuffs Heat Trea Inspection | Crimped. t | | O/S | Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short | | 1 | on Incomplete ions Incomplete/L nance led | Inclear | Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/ | ct ssing | Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other |
| | | - | , | rube | | Drill Holes | - | Offset | l | L | Trower ross/ | Surge | Other |
| | | Ripples in Torque W | | vtrucio | <u> </u> | | - | ł | alibration | | | | |
| | | Turning Se | | xti u5101 | '' - | Drawing Finish | - | 1 | Calibration | | | | |
| | | Wave/Twi | | e | - | Folio | - | 1 | equence Dimensions | | | | |

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

November-15-12 1:03:07 PM

Work Order ID:

93491

Parent Item:

D206-781-023

Parent Item Name:

Floor Protector (Passenger Cabin)

AN525-10R6 Screw

Purchased

No

110

Each

215.0000

10

Start Date: 11/15/12

Start Qty: 2.00

Required Date: 11/16/12

Required Qty: 2.00

8-

2m 22

| Location | ! | Loc Oty | Loc Code |
|----------|--------|---------|----------|
| ST344 | | 89 | |
| | 122814 | 89 | |
| ST345 | | 100 | |
| | 122151 | 100 | |
| ST346 | | 26 | |
| | 118757 | 23 | |
| | 119309 | 3 | |
| | | | |

| NCR: Y | es / No | | | | WORK ORDER NON- | CON | FORN | ANCE / UP | DATE | | _ | |
|---------------------------------------|------------|-----------|------------|-----------------|--------------------------------|-------------|-----------|------------------------|---------------------|--------------|----------------------------|---------------------|
| | | | · | | | | | | | QA Closed: | Date | : |
| Work Orde | r: | | | | DISPOSITION | _ | | | AGAINST DE | PARTMENT | _ | <i>ξ</i> |
| Part N | 0 | | | | Rework Scrap | - | V | Skid-tube Machining | Crosstube Small Fab | - | Water Jet d. Eng. Coor. | Engineering Quality |
| NCR N | 0 | | | | Use-as-is Work Order Update |] | | Large Fab | Finishing Composite | Rec/Stor | re/Packaging Supplier | Other |
| Root | | | | Descri | iption of work order update | ln | itial | Act | tion | Sign & | | |
| Cause | Date | Step | Qty | | or Non-conformance | Chie | ef Eng | Desc | ription | Date | Verification | QC Inspector |
| Doc/Data Equip/Tooling Operator | | | | | · | | | | | | | |
| Material | \dashv | | | | | | | | | | . | |
| Setup | | | | | | | İ | | | | | |
| Other | 7 | | | | | | | | | | | |
| Process | | | | | | | | | | | | |
| Supplier | | | | | | | | | | : | | |
| Fraining | | | | | | | | | | | | |
| Jnapproved | | | | | | | | | | | | |
| | | | | | F | FAULT | CATE | GORY | | | | |
| Landin | g Gear | | | | General | | | | | _ | | _ |
| | Bending | | | [| Bend | | Grain | | | Ovalized | | Pressure/Forced |
| | Centre No | ot Concer | ntric to (| o/s | BOM/Route | Ц٢ | łardwai | re | | Over/Under | tolerance | Temperature/Cure |
| | Cracks | | | | Broken/Damaged | | nspection | on Incomplete | | Part Incorre | ct | Weld |
| | Crushed/ | Crimped. | | | Burrs | | nstructi | ions Incomplete/ | Unclear | Part Lost/Mi | issing | Wrong Stock Pulled |
| | Cuffs | | | | Contamination | Ш | Mainte | nance | | Part Moved | | |
| | Heat Trea | it | | <u> </u> | Countersink | | ∕islabe | led | | Positioned V | Vrong | |
| | Inspection | | Tube | | Cut Too Short | | ∕lisread | | | Power Loss/ | Surge | Other |
| | Ripples in | | | L | Drill Holes | | Offset | | | | | |
| | Torque W | aves in E | xtrusion | ^ւ _ | Drawing | Щ | Out of C | Calibration | | | | |
| | Turning S | equence | | | Finish | | Out of S | equence | | | | |

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio



5.0 PARTS LIST

5.1 BELL 206 A/B

| Qty -051 | Qty -011 | Qty -021 | Part Number | Description |
|-------------|-------------|-------------|-----------------|---|
| X | | | D206-781-051 | FLOOR PROTECTOR KIT (PILOT, CO-PILOT, PASSENGER CABIN) |
| 1 | х | | D206-781-011 | FLOOR PROTECTOR KIT (PILOT AND CO-PILOT) |
| 1 | | Х | D206-781-021 | FLOOR PROTECTOR KIT (PASSENGER CABIN) |
| | 1 | | D3874-1 | FLOOR PROTECTOR, CO-PILOT |
| | 1 | | D3874-2 | FLOOR PROTECTOR, PILOT |
| | | 1 | D3875-1 | FLOOR PROTECTOR, PASSENGER |
| | | 2 | D3934-041 | CLIP ASSEMBLY |
| | 4 | | D3800-1-100-300 | LOOP STRIP |
| | 4 | | D3800-3-100-300 | HOOK STRIP |
| | | 2 | D3800-1-100-500 | LOOP STRIP |
| | | 2 | D3800-3-100-500 | HOOK STRIP |
| | 2 | | AN4-13A | BOLT |
| | | 4 | AN525-10R6 | SCREW |
| | 2 | | AN960JD416 | WASHER |
| | 2 | | NAS43DD4-20 | SPACER |
| | 1 | | NAS43DD4-64 | SPACER |

5.2 BELL 206 L/L1/L3/L4

| Qty -053 | Qty -011 | Qty \ -023 | Part Number | Description |
|-------------|-------------|---------------|-------------------|---|
| Х | | | D206-781-053 | FLOOR PROTECTOR KIT (PILOT, CO-PILOT, PASSENGER CABIN) |
| 1 | х | | D206-781-011 | FLOOR PROTECTOR KIT (PILOT AND CO-PILOT) |
| 1 | | Х | D206-781-023 | FLOOR PROTECTOR KIT (PASSENGER CABIN) |
| | | | | |
| | 1 | | D3874-1 | FLOOR PROTECTOR, CO-PILOT |
| | 1 | | D3874-2 | FLOOR PROTECTOR, PILOT |
| | | 177= | -D3898-1- | FLOOR PROTECTOR, PASSENGER |
| | | (25) | D3934-041 | CLIP ASSEMBLY |
| | | | | |
| | 4 | | D3800-1-100-300 | LOOP STRIP |
| | 4 | | D3800-3-100-300 | HOOK STRIP |
| | <u> </u> | -2- | ID3800-1-100-500 | = LOOP-STRIP > |
| | | 72 - | _D3800-3-100-500- | CHOOK STRIP- |
| | 2 | | AN4-13A | BOLT |
| | | C-4 <u>^</u> | -AN525:10R6 | SCREW |
| | 2 | | AN960JD416 | WASHER |
| | 2 | | NAS43DD4-20 | SPACER |
| | 1 | | NAS43DD4-64 | SPACER |

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Revision: A

Date: 10.10.28